

May-20-14 11:37:22 AM

Page 1

Quality Control

DAS
37
9-89

19/05/22

DAS
37
9-89

19/05/22

Work Order ID 119727

May-20-14 11:37:22 AM

119727

Page 2

Item ID: D5080-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Striker Plate
 Start Date: 5/20/14 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 5/23/14 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 27 9-89 14/5/23				75 com			
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00			DAS 30 9-89	75			14/6/26
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 14/5/20				75 com			

Work Order ID 119727

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Item ID: D5080-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Striker Plate
 Start Date: 5/20/14 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 5/23/14 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST/30</u>	0.00							
150									
Packaging	Memo	0.00				75X		DAS 28 300	MAY 29 2014
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

14/5/30 *[Signature]*
 MP
 14-5-28

Picklist Print

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Page 1

Work Order ID: 119727

119727

Parent Item: D5080-3

D5080-3

Parent Item Name: Striker Plate

Start Date: 5/20/14

Required Date: 5/23/14

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A 14.03.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No				sf	572.1100		2			
M304S18GA										**			
304/316 .050 Sheet													

mm 14/05/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	560.11	
117188	3	
117766	5	
120604	5	
122325	3	
123155	3	
124572	38	
M126647	39.75	
M128254	102.11	
M128435	187.25	
<u>M128864</u>	174	
MAT020	12	
124029	2	
M126098	10	

25

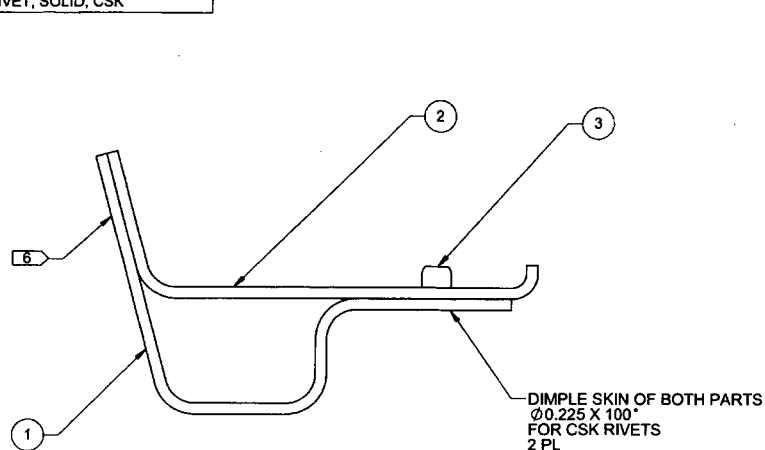
FIRST ARTICLE INSPECTION CHECKLIST

DAS		DAS			
Measured by:	37 9-89 / mm	Audited by:	27 9-89	Preliminary Approval:	
Date:	14/05/23	Date:	14/5/23	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

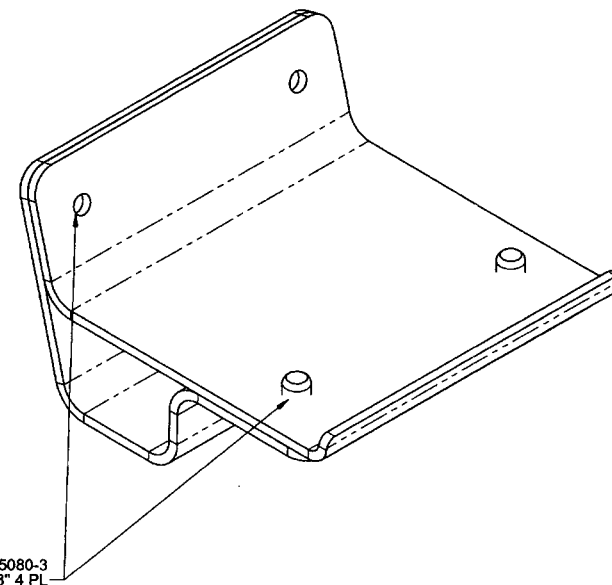
10.04.15

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5080-041	STRIKER PLATE ASSY
1	1	D5080-1	ANGLE BRACKET
2	1	D5080-3	STRIKER PLATE
3	2	MS20426AD4-4	RIVET, SOLID, CSK



D5080-041 STRIKER PLATE ASSY

TRANSFER MARK HOLES FROM D5080-3
TO D5080-1 AND DRILL Ø0.128" 4 PL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 119723 MJS
14-05-28

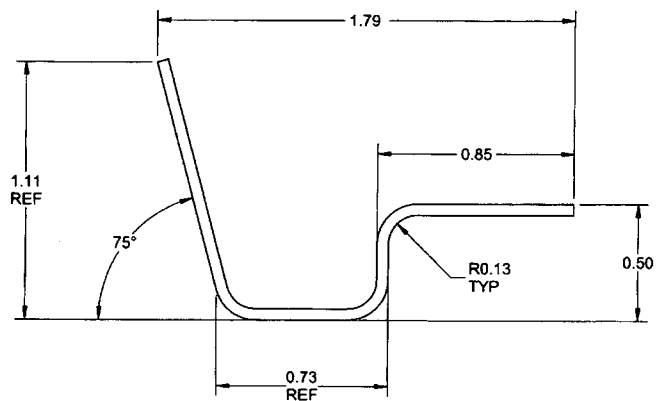
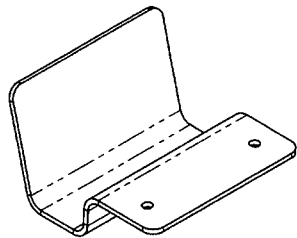
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.13 lbs

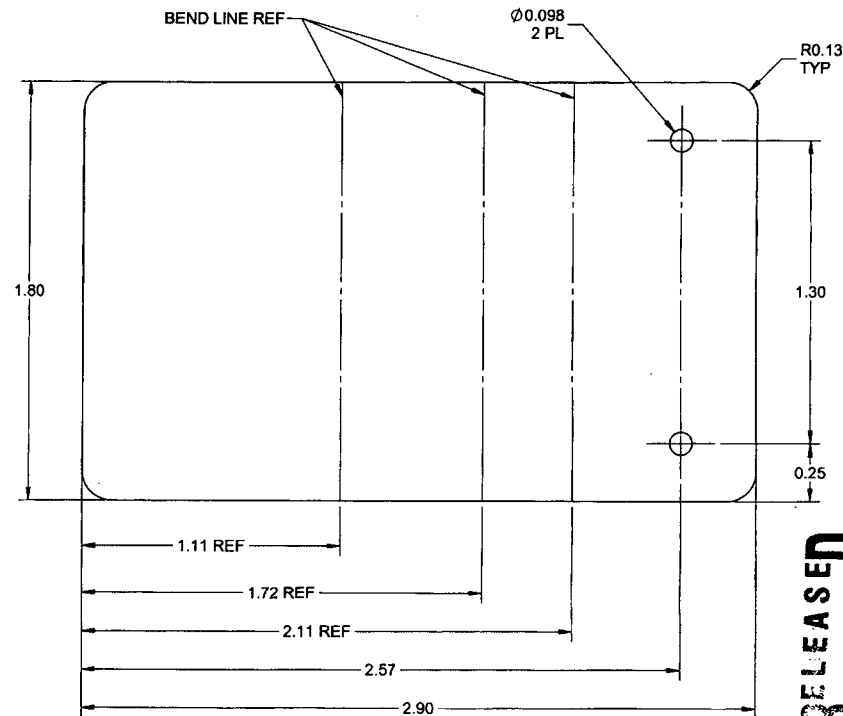
RELEASED
2014-04-23

A		NEW ISSUE		ML	14.03.24
REV.		DESCRIPTION		BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	ML			SHEET 1 OF 3	
CHECKED	AJS	DRAWING NO.		REV. A	
MFG. APPR.	DD	D5080		SCALE	
APPROVED	MP	TITLE		NTS	
DE APPR.	DS	STRIKER PLATE ASSY			
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



D5080-1 ANGLE BRACKET
MAKE FROM D5080-1F



D5080-1F FLAT PATTERN

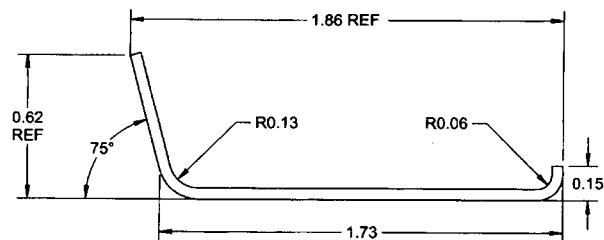
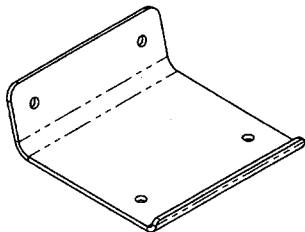
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.048" THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

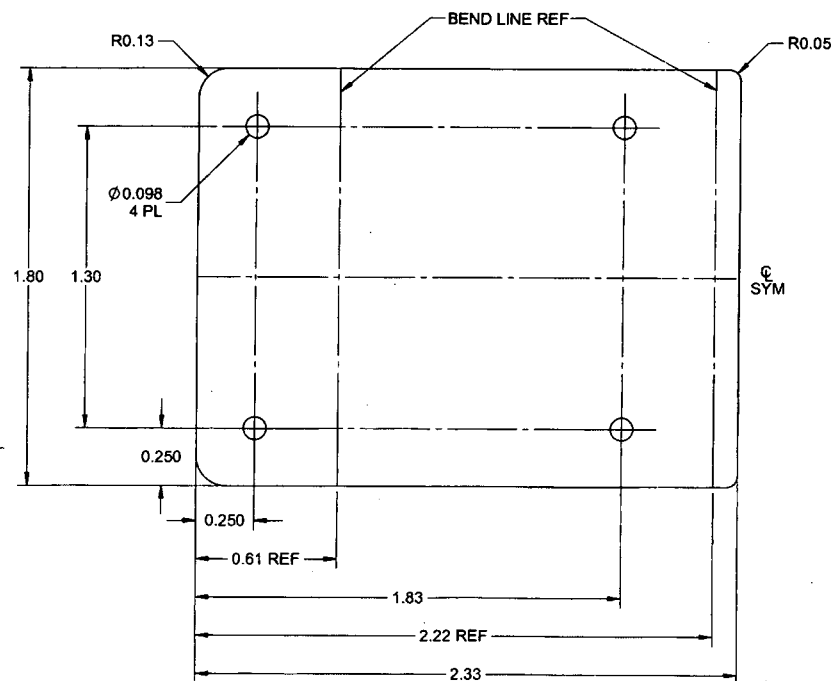
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DRAWN	ML		
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MFG. APPR.	DD	D5080	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STRIKER PLATE ASSY	NTS
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RELEASED
2014-06-23



D5080-3 STRIKER PLATE
MAKE FROM D5080-3F



D5080-3F FLAT PATTERN

RELEASED
2014-04-23

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.048" THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S18GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

APPROVED

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DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5080	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STRIKER PLATE ASSY	NTS
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